

5/31

DART AEROSPACE LTD	Work Order:	23752
Description: Bracket	Part Number:	D3146-2
Dwg: D3146 Rev. A	Qty:	5
Page 1 of 1		


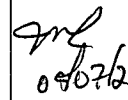
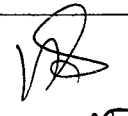
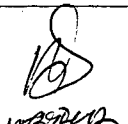


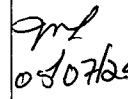
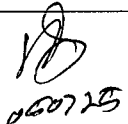
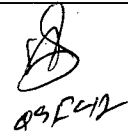
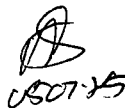
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	05.07.06	5
2	MV	Cut blanks: 4.500" x 1.250" x 3.100" long Bar Material: 6061-T6/T651 (QQ-A-200/8) 1.250" thick (M6061T6B1.250x04.500) Identify for D3146-2 Batch: <u>M17655</u>	Er	05/07/20	5
3	MV	Machine as per Folio FA419 and Dwg D3146 Identify as D3146-2	En	05/07/23	5
4	QC2	Inspect parts as they come off the CNC machine	En	05/07/23	5
5	QC8	Second check	Am	05/07/23	5
6	MV	Deburr and Tumble	En	05/07/23	5
7	FP	Chemical Conversion Coat as per QSI 005 4.1	PML	05-7-22	5
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	FC	05 08 03	5
9	QC3	Inspect Powder Coat	MM	05 08 04	5
10	QC5	Inspect work to Step 9		05-08-04	5
11	ST	Identify and Stock in Spacedoor Cell	CD	05/08/04	5
12	AC	Cost / part <u>83.87</u>	Sqr	05-08-09	5
13	DC	Close W/O <u>65.62</u> Inspect Level 21	GP	05/08/05	5


Rev	Date	Change	Revised By	Approved
A	04.04.28	New issue	KJ/JLM	

RELEASED

04.04.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/07/23	# 3	Three (3) parts scrap. Setup Problems.	 W00723	Scrap/destroy + Replace.	 05/07/25	 05/07/25	 W00723	 05/07/25
05/07/23	# 3	one part scrap. face mill removed a chunk	 05/07/23	Scrap/destroy + Replace.	 05/07/25	 05/07/25	 05/07/23	 05/07/25

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/08/05

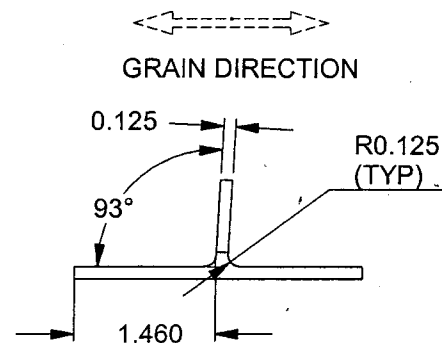
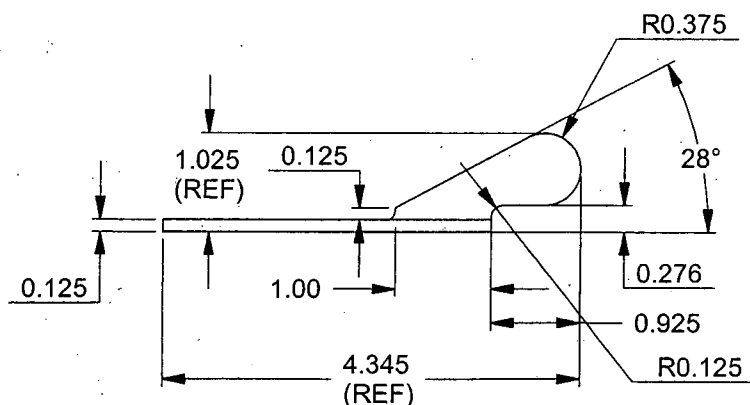
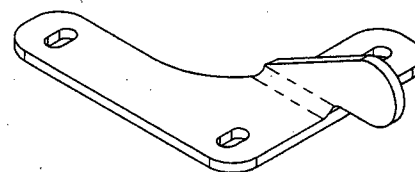
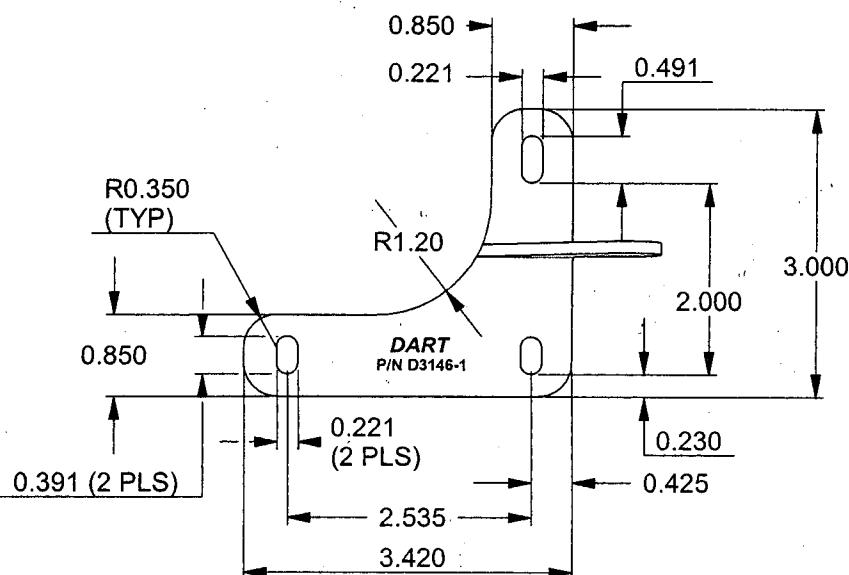
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3146	REV. A SHEET 1 OF 1
DATE 02.04.25		TITLE BRACKET	SCALE 1:2
A	02.04.25	NEW ISSUE	

RELEASED
02.05.27 #



D3146-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-27
(D3146-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-28)

SHOP COPY

RETURN TO
ENGINEERING

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

UNITED STATES COPY

WORK ORDER

NO. 23752

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DART AEROSPACE LTD		Work Order: 23752
Description: Bracket		Part Number: D3146-2
Inspection Dwg: D3146	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000	+/-0.010	2.997	/			
2.000	+/-0.010	1.998	/			
0.230	+/-0.010	0.228	/			
0.425	+/-0.010	0.422	/			
3.420	+/-0.010	3.423	/			
2.535	+/-0.010	2.534	/			
0.221	+/-0.010	0.226	/			
0.391	+/-0.010	0.386	/			
0.221	+/-0.010	0.226	/			
0.850	+/-0.010	0.851	/			
R0.350	+/-0.010	0.350	/			
0.850	+/-0.010	0.850	/			
0.221	+/-0.010	0.226	/			
0.491	+/-0.010	0.492	/			
0.125	+/-0.010	.127	/			
1.025	+/-0.010	1.027	/			
R0.375	+/-0.010	0.375	/			
28°	+/-0.1°	28°	/			
0.276	+/-0.010	.280	/			
0.925	+/-0.010	.930	/			
R0.125	+/-0.010	R.125	/			
REF. 4.345	+/-0.010					Cannot measure
0.125	+/-0.010	.129	/			
93°	+/-0.1°	93°	/			
R0.125	+/-0.010	R.125	/			
Grain Direction	N/A					

Measured by: EP/SD	Audited by: JML	Prototype Approval:	N/A
Date: 03.07.22	Date: 05/07/23	Date:	N/A

Rev A	Date	Change New Issue	RELEASED	Revised by KJ/JLM	Approved
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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 05, 2005
01:35 pm

Work Order No : 0023752
Project Name : D3146-2
Project For : WK531
Work Order Type : Main
Main WO Number :
House Part Number : D3146-2
Description : Hinge Bracket
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 07-05-05
Est Finish Date : 08-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00